



Dart Aerospace Ltd.
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D3492-3

Job Sheet 179055



Part No: D3492-3

Job Qty: 300 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/13/18

Job Tracking No:

Due Date: 7/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	300 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Machining-2		
100	Hardinge	300 pcs	7/2/18	7/2/18	0.00	11.24	Hardinge		
120	QC	300 pcs	7/2/18	7/2/18	0.00	0.00	QC8		
130	HandFinish	300 pcs	7/2/18	7/2/18	0.00	1.03	HandFinish1		
135	Outsource	300 pcs	7/2/18	7/2/18	0.00	0.00			
140	Powdercoat	300 pcs	7/2/18	7/2/18	0.00	0.60	Powdercoat1		
145	Packaging	300 pcs	7/2/18	7/2/18	0.00	0.00			
150	QC	300 pcs	7/2/18	7/2/18	0.00	0.00	QC3		
160	Packaging	300 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-1	FP-001	
170	QC21-SA	300 Ea	7/2/18	7/2/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio FA632 & Dwg D3492

Descriptions: 140 - (Flat End Only)

160 - LOCATION : FP001

START: 8:35 FINISH: 9:05 TEMP: 320° M138839.

DAS 21 9-89 JUL 20 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.750	6061-T6 Round Bar .750"	17.7000 ft (.059 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.750	18	31	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.750inches ± 0.010	0.760 0.740		
2	Plug	0.582inches + 0.000 - 0.002	0.582 0.580		
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		
4	Plug	0.060inches ± 0.005	0.065 0.055		
5	Plug	0.060inches ± 0.005	0.065		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																											
☐ Environment	☐ Design	☐ Doc/Data	☐ Equip/Tooling	☐ Handling/Pre	☐ Material	☐ Internal Transport	☐ Tribal Knowledge	☐ LOA	☐ Substation	☐ Past Expiry Date	☐ Misidentified	☐ No Re-verification	☐ Operator	☐ Offset/Setup	☐ Supplier	☐ Training	☐ Use for Testing	☐ Poor Information	☐ Rushing	☐ Product Improvement	☐ Process Improvement	☐ Manufacturing Process	☐ Past Due	☐ Pressure/Forced	☐ Bending	☐ Centre Not Concentric	☐ Cracks	☐ Crimp/Kink/Ripple/Wave	☐ Cuffs	☐ Crushing	☐ Heat Treat	☐ Wave/Twist in Tube	☐ Marks/Chatter	☐ Temperature/Cure	☐ Set-up	☐ BOM/Route	☐ Broken/Damage/Defect	☐ Inspection Incomplete/Unqualified	☐ Contamination	☐ Countersink	☐ Cut Too Short	☐ Instructions Incomplete/Unclear	☐ Drill Holes	☐ Power Loss/Surge	☐ Folio/Program	☐ Grain	☐ Weld	☐ Wrong Stock Pulled	☐ Out of Sequence	☐ Off-set	☐ Mislabeled	☐ Fit/Function	☐ Misaligned/off center	☐ Positioned Wrong	☐ Outside Dimensions	☐ Over/Under tolerance	☐ Part Incorrect	☐ Part Lost/Missing	☐ Part Moved	☐ Drawing	☐ Finish	☐ Misread	☐ Turning Sequence
																								OTHER : _____																																							

			0.055
6	Plug	0.500inches ± 0.010	0.510 0.490
7	Plug	0.090inches $+ 0.000$ $- 0.002$	0.090 0.088

Plex 6/13/18 11:52 AM Dart.lajeunesse.marie

